

5/15

SPUR

DART AEROSPACE LTD	Work Order:	22493B
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	11 15 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HA	05.02.21	15
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	HA	05.03.17	14
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15926	ML	05/03/04	14
4	MV	Inspect material for defects or damage prior to machining	ML	05/03/04	14
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	ML	05/03/11	14
6	QC2	Inspect parts as they come off the CNC machine	ML	05/03/11	14
7	MV	Deburr	ML	05/03/11	14
8	QC8 & 5	Second inspection	TE	05/03/11	14
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434/B19540/B21185 12 D2274 Radius Block B20427/B21585/B21846 2 D2432F 24" Bearpaw B22493 6 D2438 Clamp B21189 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433 12 AN4-15A Bolt M15321 12 AN4-17A Bolt M14526 24 AN960JD416 Washer M13993 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2	JG	05/03/16	11
10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/03/17	11
11	PK	Identify and pack for shipping as per PPP K10008 Rev. E	CL	05/03/17	11
12	AC	Cost / part 251.50	Sur	05.03.21	11
13	DC	Close W/O 274.25 Inspect Level 21	HA	05.03.17	11

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	#

05-03-17

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22493
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060	✓	Vern	
B	5.500	+/-0.030	5.500	✓	Vern	
C	0.200	+/-0.030	0.203	✓	Vern	
D	0.25 x 45°	+/-0.030	0.230x45°	✓	Vern	
E	R0.250	+/-0.030	R0.250	✓	R-G	
F	0.250	+/-0.010	0.254	✓	Vern	
G	0.625	+/-0.030	0.612	✓	Vern	
H	0.375	+/-0.010	0.382	✓	Vern	
I	0.950	+0.030/0.010	0.960	✓	Vern	
J	19.000	+/-0.030	19.000	✓	M-Tape	
K	3.14	+/-0.030	3.126	✓	Vern	
L	3.28	+/-0.030	3.270	✓	Vern	
M	Ø0.260	+0.005/-0.000	Ø0.260	✓	Vern	
N	Ø0.93	+/-0.030	Ø.929	✓	Vern	
O	0.30	+0.030/-0.000	0.305	✓	Vern	
P	23.750	+/-0.030	23.750	✓	M-Tape	
Q	7.375	+/-0.030	7.375	✓	Vern M-Tape	
R	4.250	+/-0.010	4.250	✓	M-Tape	
S	2.000	+/-0.030	2.000	✓	Vern	
T	9.000	+/-0.010	9.000	✓	M-Tape	
U	9.000	+/-0.010	9.000	✓	M-Tape	
V	0.375	+/-0.010	0.380	✓	Vern	

Measured by: <u>me</u>	Audited by: <u>SA</u>	Prototype Approval:	N/A
Date: <u>05/03/07</u>	Date: <u>03/03/07</u>	Date:	<u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/p206-559-015	KJ/RF

RELEASED

04.01.15





Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 21, 2005
07:40 am

Work Order No	: 0022493	Department Code:	
Project Name	: K10008	Burden Flags	: NNNNNNNN
Project For	: WK515	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10008	Invoice Number	:
Description	: Bearpaw kit 19" x 24"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 02-18-05		
Est Finish Date	: 03-30-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00